

Date: Wednesday, 12/14/2005 4:02:31 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET BASE ASSEMBLY (350)			
Job Number	: 25233C						
Estimate Number	: 10189						
P.O. Number	: N/A			Part Number	: D2221		
This Issue	: 12/14/2005	S.O. No.	: N/A	Drawing Number	: D2221 REV F		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: N/A		Type	: LARGE FAB ASSY			
Previous Run	: 25232C			Drawing Revision	: F		
Written By	: SEE COMMENT Below			Material	: N/A		
Checked & Approved By	: SEE COMMENT Below			Due Date	: 1/20/2006		
Comment	: Est Rev:J 05.09.02 Added D3442-1KJ/JLM			Qty:	1	Um: Each	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31661	Basket Hoop
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D3166-1	RIB	<u>B25249</u>

PD 06-01-11

2.0	D22323	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-3	Hinge bracket	<u>B24527</u>

PD 06-01-11

3.0	D2325	Support Gusset (350 Bask)
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2325	Support Gusset	<u>B24529</u>

PD 06-01-11

4.0	D23273	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2327-3	Bushing	<u>B24530</u>

PD 06-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 25233C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D2581 Mounting Bracket B23584

PD 06-01-11

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3442-1 Shim B23544

PD 06-01-11

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 37.8000 sf(s)/Unit Total : 37.8000 sf(s)

Pick:

Qty Part Number Description Batch  
36 sf M304EX0.75-16F Expanded Metal M19149

PD 06-01-11

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M19447

PD 06-01-11

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

PD

06-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 25233C		Part Number: D2221
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
10.0	QC9/6	DDIMENSIONAL & WELDING INSPECTION 
Comment: DDIMENSIONAL & WELDING INSPECTION		ND 06/01/17
11.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		FC 06 01 18
12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		M 06 01 18
13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Seal support gusset seam with white sikaflex-291 Batch: M19134 Expiry date: 06/06/20		SAP 06:01 18
14.0	DC	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL Inspection Level 21		CD 06/01/17
Job Completion 		U 06/01/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
		C 95.11.21 SEPARATE BASKET AND LID	

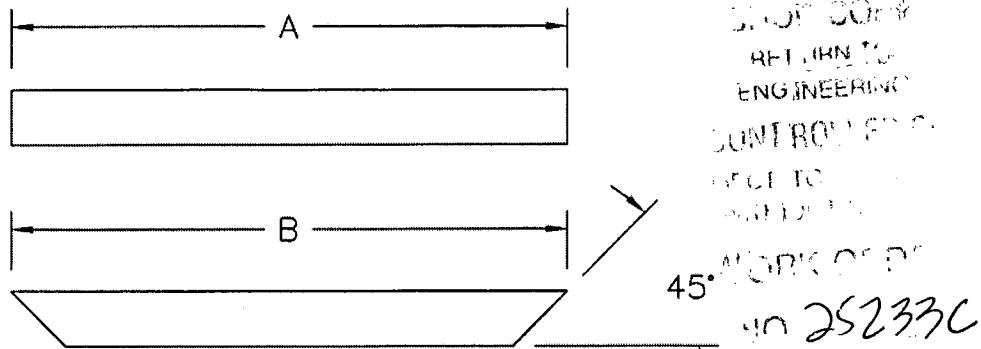
RELEASED

05.08.19 *[initials]*

C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

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WANDEL IN DE TEGENSTAND VAN DE AANSTALTING

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SKIN INSIDE SURFACE OF  
BASKET WITH MESH. TACK  
WELD EACH END OF STRAND  
TO FRAME

1.75  
(REF)

92.50

46.25

D2221-1 (2) 1.75

D2221-7

Ø0.257 (TYP 5 PLACES)  
(DRILL WHEN ASSEMBLING WITH  
D2989-041/-043 LID ONLY)

6.50  
(TYP BOTH ENDS)

D2221-5 (2)

D2221-3 (2)

TYP

TYP

TYP

TYP

25.50

18.88 55.25 18.87

30.00 34.50 30.00 (REF)

D2581 (2)

D2232-3 (REF)

D3442-1 (REF)

B

A

56.00 (REF)

D2221-7 (REF)

19.63

D2235-1

19.62

96.00 ± 0.01

DETAIL D

19.63 19.62

RECEIVED  
MAY 10 1968  
25233C  
SUBJECT TO  
WILLIAMS  
W. O. R.  
D2221 BASKET BASE ASS

D2221 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

D2232-3

D3442-1

DETAIL D  
(SCALE 1:1)  
(TYP BOTH ENDS)

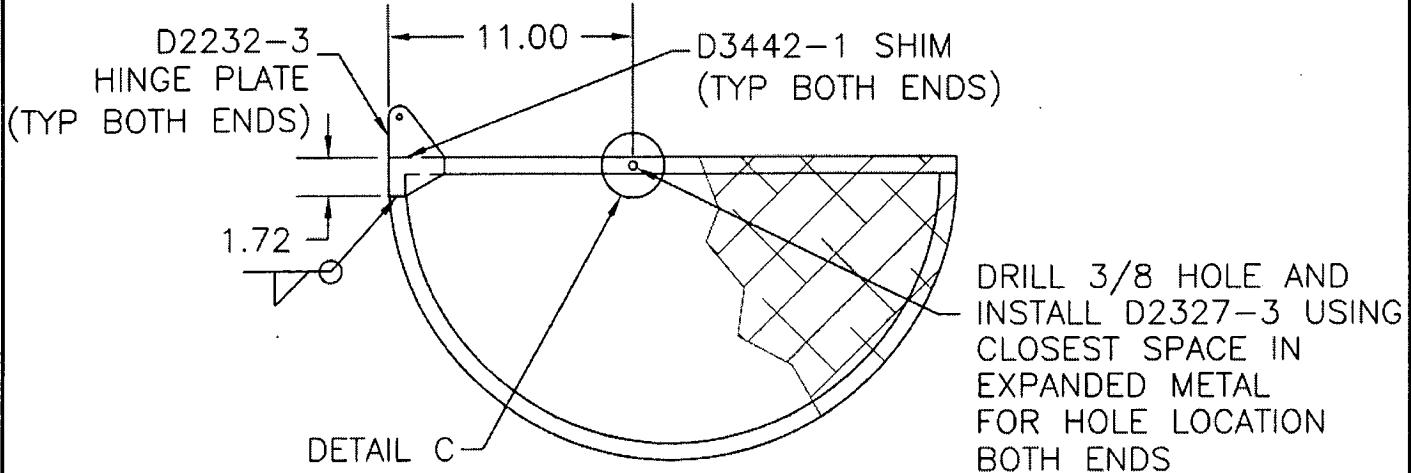
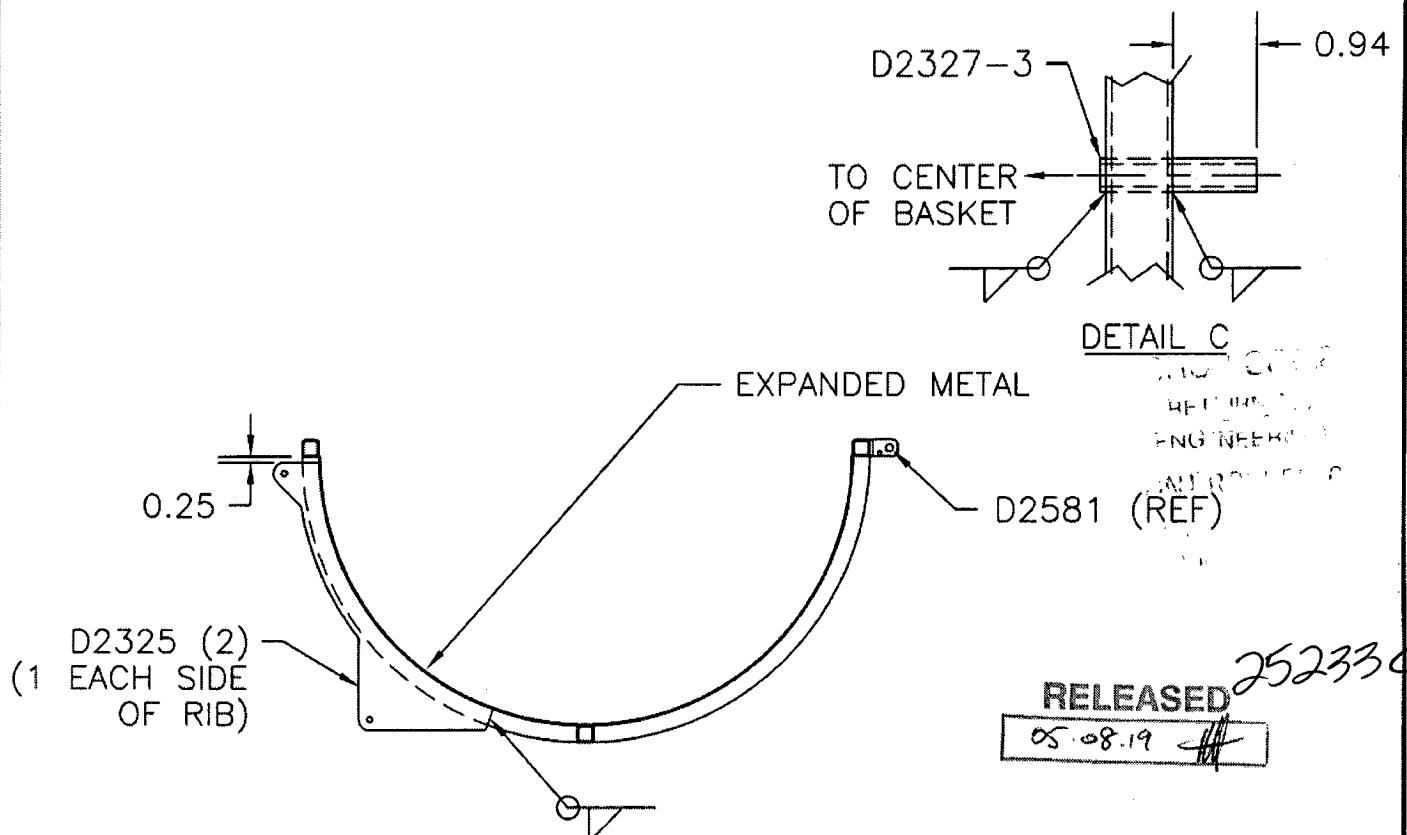
M304EX0.75-16F)

NOTED

		<b>DART AEROSPACE LTD</b>	
		HAWKESBURY, ONTARIO, CANADA	
DESIGN	EW	DRAWN BY	
CHECKED		PH	
APPROVED		DRAWING NO.	
DATE		D2221	
05.06.07		TITLE	SHEET 2 OF 3
		BASKET BASE ASSEMBLY (350)	REV. F
		1:20	SCALE

**DART**

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221 REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350) SCALE 1:8

SECTION A-A SAME BOTH END RIBSSECTION B-B SAME BOTH CENTER RIBS

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05.08.19 *[Signature]*